

Work Order ID 69669

Monday, May 16, 2011 9:26:58 AM



Page 1

Item ID: D3552-19

Accept



Setup Start



Revision ID:

Item Name: Door Prop

Stop



Start Date: 5/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/05/16

Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3552	G

100



PURCHASING

Purchasing

Memo

0.00

0.00

CL 11/05/16 12

Purchasing

Issue P/O: 14069

Purchase Part Number: B8-154-387-060N

Supplier: LS Technologies

Certificate of conformity is required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

Fujioffis 12

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

120



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Test for correct pressure

S Mar/24

47

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action			Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date					

• NOTE: Date & initial all entries

Work Order ID 69669

Monday, May 16, 2011 9:26:58 AM



Page 2

Item ID: D3552-19

Accept



Setup

Start



Revision ID:

Item Name: Door Prop

Stop



Start Date: 5/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 272

0.00

11/15/251200

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

11/15/26/25

QC

Memo

0.00

Quality Control

MF
11-05-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

- NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, May 16, 2011 9:26:56 AM

Work Order ID: 69669



Parent Item: D3552-19



Parent Item Name: Door Prop

Start Date: 5/16/2011

Required Date: 5/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.09.24 new issue DD Verf:EC
10.12.03 as per dwg rev.G DD verf:EC

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B8-154-387-060N Gas Spring		Purchased		No		110	Each	0.0000	1	12		16/16/18 (12)	

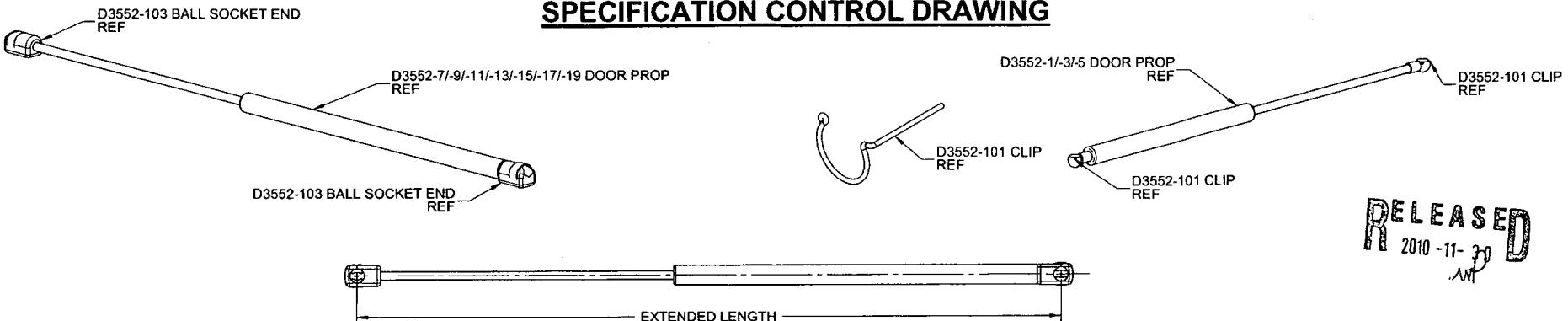
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



RELEASED
2010-11-20
AM

DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER	ALTERNATE SUPPLIER	ALTERNATE SUPPLIER P/N OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N	N/A	N/A
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N	N/A	N/A
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N	N/A	N/A
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N	N/A	N/A
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N	N/A	N/A
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N	N/A	N/A
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N	N/A	N/A
D3552-15	DOOR PROP	139/5.47	386/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300N	SUSPA, Inc.	16-2-210-139-A101-B101-400N
D3552-17	DOOR PROP	139/5.47	386/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156N	SUSPA, Inc.	16-2-210-160-A101-B101-156N
D3552-19	DOOR PROP	139/5.47	386/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060N	SUSPA, Inc.	16-2-210-139-A101-B101-060N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9	N/A	N/A
③ D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10	N/A	N/A

D3552-X DOOR PROP

G	FOR -15, FORCE:300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 1395.47 WAS 160/6.30, EXT LG: 589/15.2 WAS 407/6.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.05.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>IS</i>	DRAWING NO.	REV. G
MFG. APPR.	N/A	D3552	SHEET 1 OF 1
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	DOOR PROP	NTS
DATE	10.11.01	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) IDENTIFICATION: IDENT P/N D3552-X & B/N PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19 DOOR PROPS



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14069

Purchase Order Date 5/11/2011
PO Print Date 5/16/2011

Page Number 2 of 2

Order From : VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

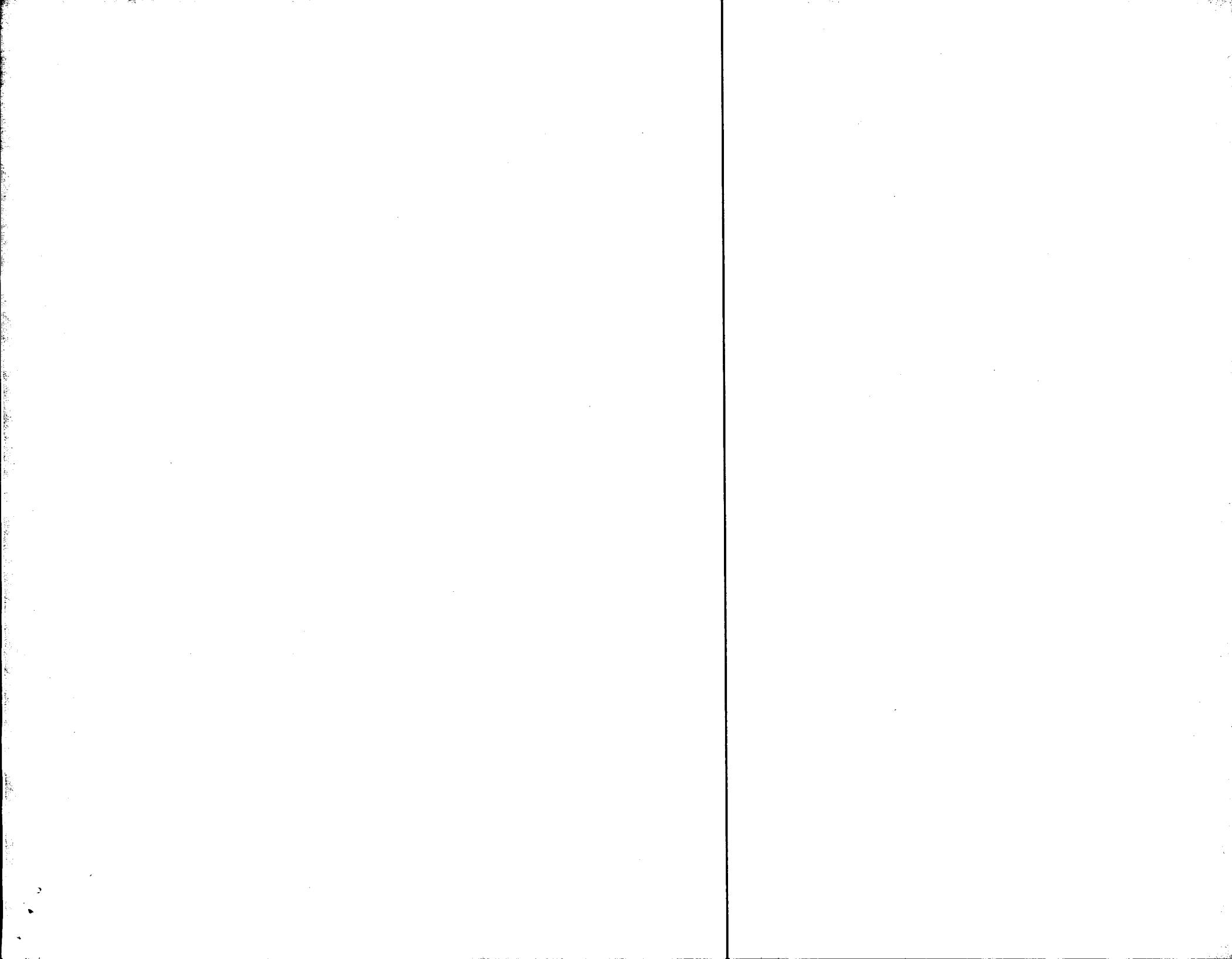
Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect
5 B8-154-387-060N	Gas Spring	5/20/2011
		Yes
		12.00 FedEx PI collect
		\$26.5000
		\$318.00
		Each
	Special Inst:	AS PER DWG D3552 REV. G B69669
		PO Total: \$2,295.94

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 2

Change Date: 5/16/2011



LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

Date	Invoice #
5/16/2011	7288

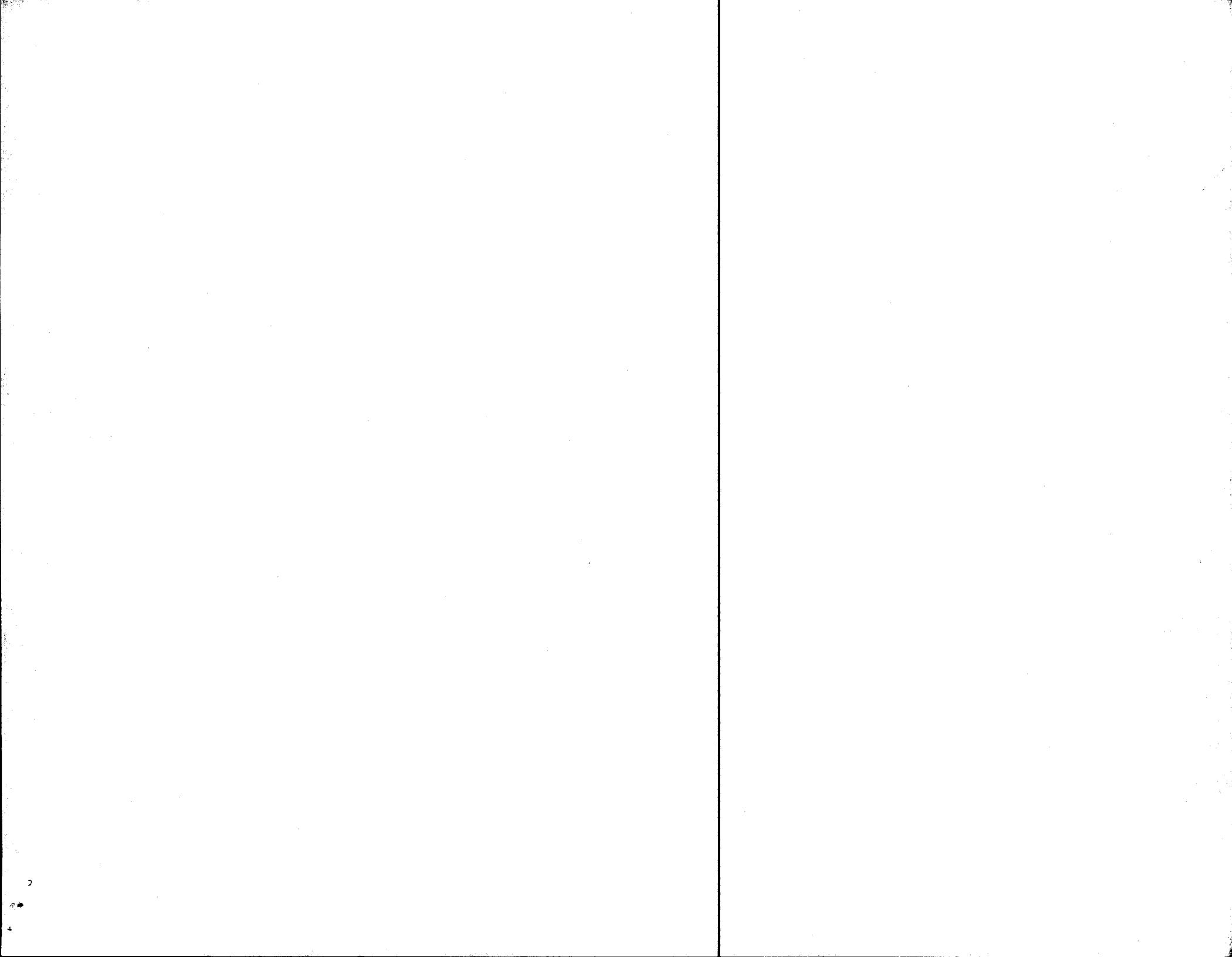
Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

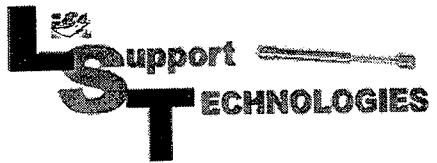
Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
14069	5/16/2011	Fed-Ex		

Qty	Description
12 20 10 12 12	BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut D2807 Stainless Gas Spring (6/15-164/50-115N) B6-220-530-140N Gas Spring B8-154-387-156N Gas Spring B8-154-387-60N Gas Spring

Shipping Via FED EX Tracking # 797101196445





303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

**12 Units : BS104 .39 DIA BALL STUD ZINC PLATED
5/16-18 THREAD .75 LENGTH W/Locknut**

20 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

10 Units: B6-220-530-140N Carbon Steel Gas Spring

12 Units: B8-154-387-156N Carbon Steel Gas Spring

12 Units: B8-154-387-060N Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : May 2011

This product is ROHS compliant.

W05/24

We certify no mercury was used in the manufacture of this order.

Purchase Order # 14069

Invoice # 7288

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read 'Nolan Fehr'.

Nolan Fehr
Manager